



(11)

**EP 0 807 466 A2**

(12)

**EUROPEAN PATENT APPLICATION**

(43) Date of publication:  
19.11.1997 Bulletin 1997/47

(51) Int Cl.<sup>6</sup>: **B01J 35/04**

(21) Application number: 97303329.3

(22) Date of filing: 16.05.1997

(84) Designated Contracting States:  
DE FR GB IT

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**(30) Priority: 17.05.1996 JP 123032/96**

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**(54) Honeycomb structural body**

(57) A honeycomb structural body (1) comprises a plurality of passages (3) aligned in its axial direction which are defined by partition walls (2). The ratio of L/D is in the range of 0.4-1.3, where d is a diameter of an inscribed circle of the periphery of the honeycomb struc-

tural body on a plane perpendicular to its axial direction, and  $L$  is a length along the axial direction of the honeycomb structural body. High resistance to spalling can be obtained, particularly when the partition wall thickness is less than 0.1 mm and the cell density is more than 100 per  $\text{cm}^2$ .

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## Description

### Background of the Invention

#### (1) Field of the Invention

The present invention relates to a honeycomb structural body especially used as a catalyst carrier in an exhaust gas purifying apparatus of a firing apparatus such as a boiler or a combustion apparatus such as an internal combustion engine.

#### (2) Related Art Statement

As the catalyst carrier of the exhaust gas purifying apparatus, the honeycomb structural body has been used. Generally, just after the automobile engine starts, i.e. in a so-called "cold start" state, in which a temperature of the exhaust gas from an exhaust gas generation source is low, it is required to increase a temperature ascending rate of the catalyst in the exhaust gas purifying apparatus so as to activate the exhaust gas purifying function as soon as possible. In order to achieve this requirement, a technique, such that a thermal capacity of the catalyst is made smaller and thus a temperature ascending rate is made faster by forming a partition wall of the honeycomb structural body thinner to an order of 0.15 mm or 0.1 mm, is disclosed in Japanese Patent Laid-Open Publication No. JP-A-7-39761.

Moreover, in order to further improve the exhaust gas purifying performance, a technique, such that a geometric surface area of the honeycomb structural body is increased i.e. the number of passages per unit area on a surface thereof perpendicular to a passage extending direction (hereinafter, sometimes called as cell density) is increased, is disclosed in papers of No. 960560 and No. 960261 of SAE (Society of Automotive Engineers) in United States.

During the discussion of the above mentioned prior arts, the following result is found. That is to say, in order to obtain an excellent exhaust gas purifying performance of the catalyst carrier including a ceramic honeycomb structural body, if the partition wall is formed extremely thinner to an order of smaller than 0.1 mm, and if the cell density is increased to an order of larger than 100 pieces per 1 cm<sup>2</sup>, a spalling strength of the honeycomb structural body indicating a thermal shock resistivity is largely decreased only when a ratio of L/d, wherein d is a diameter of the honeycomb structural body and L is a length thereof, exists in a certain range.

The spalling strength mentioned above is estimated as follows. At first, the honeycomb structural body is heated by an electric furnace or a burner using combustion gas and then cooled. Then, whether or not a defect of the honeycomb structural body such as cracks is generated is observed. In this case, the spalling strength is estimated by a safety temperature obtained as the highest temperature at which the honeycomb structural body

shows no defect. The spalling strength using the electric furnace is defined by automotive standard M505-87 issued by Society of Automotive Engineers of Japan, Inc. Moreover, as a fracture type due to the crack generation mentioned above, it is found that there is two types. That is to say, as shown in Fig. 1a, one type is a ring crack 4 in which the honeycomb structural body 1 is broken in the directions at a plane substantially perpendicular to an axial direction of passages 3 defined by partition walls 2. Further, as shown in Fig. 1b, the other type is an end crack 5 in which a crack is generated at one end surface or both end surfaces of the honeycomb structural body 1.

When the catalyst carrier including the honeycomb structural body is used in the automobile, it is better that the honeycomb structural body has a higher spalling strength mentioned above. This is because the higher spalling strength is an extremely significant characteristic in the case that the honeycomb structural body is exposed to a high temperature exhaust gas as compared with the conventional one or in the case that a temperature of the exhaust gas during a high speed driving becomes higher so as to improve fuel consumption, since it is necessary to arrange the catalyst carrier in the vicinity of the engine according to the severe exhaust gas regulation. Then, if the cracks mentioned above are generated during an actual use due to the low spalling strength, a decrease of exhaust gas purifying performance, a decrease of engine power in accordance with pressure loss increase, and a generation of noise from the exhaust system occur. From the viewpoints mentioned above, even in the honeycomb structural body having an improved exhaust gas purifying performance, it is desired to obtain a honeycomb structural body having higher spalling strength.

### Summary of the Invention

An object of the invention is to eliminate the drawbacks mentioned above and to provide a honeycomb structural body having a high spalling strength while maintaining a high exhaust gas purifying performance.

According to the invention, a honeycomb structural body comprises a plurality of passages aligned in its axial direction which are defined by partition walls, wherein a ratio of L/d is in a range of 0.4-1.3, where d is a diameter of an inscribed circle of the periphery of the honeycomb structural body on a plane perpendicular to its axial direction, and L is a length along the axial direction of the honeycomb structural body.

In the present invention, it is found that the honeycomb structural body having an excellent spalling characteristic can be obtained by setting a ratio of L/d in a range of 0.4-1.3, preferably 0.6-1.1, more preferably 0.7-1.0, most preferably 0.8-0.9, where d is a diameter of an inscribed circle of the honeycomb structural body and L is a length thereof. Moreover, it is found that this effect is particularly remarkable in the case that a thick-

ness of the partition wall is smaller than 0.1 mm and the number of the passages is 100 pieces per 1 cm<sup>2</sup>.

#### Brief Description of the Drawings

Figs. 1a and 1b are schematic views for explaining a fracture type of a honeycomb structural body under an estimation test of a spalling strength;

Fig. 2 is a schematic view showing a shape of the honeycomb structural body used in the embodiment according to the invention;

Fig. 3 is a schematic view illustrating a construction of an apparatus used for the estimation test of the spalling strength according to the invention;

Fig. 4 is a graph depicting one embodiment of a heat curve in the estimation test of the spalling strength according to the invention;

Fig. 5 is a graph showing a relation between a safety temperature and a ratio of L/d of the honeycomb structural body according to the invention;

Fig. 6 is a graph illustrating a relation between the safety temperature and a thickness of the partition wall of the honeycomb structural body as a preferable example according to the invention; and

Fig. 7 is a graph depicting a relation between the safety temperature and a cell density of the honeycomb structural body as a preferable example according to the invention.

#### Description of the Preferred Embodiments

The invention is particularly applicable to extruded fired monolithic (one-piece) honeycomb bodies. The experiments described below employed such bodies.

Hereinafter, the present invention will be explained according to actual experiments. At first, as shown in Fig. 2, a honeycomb structural body 1 made of cordierite in which a plurality of passages 3 aligned in its axial direction which are defined by partition walls 2 was prepared. In this case, a ratio of L/d was varied, where d is a diameter of an inscribed circle of the honeycomb structural body 1 and L is a length of the honeycomb structural body 1. Then, as shown in Fig. 3, a spalling strength was estimated by using an apparatus comprising a burner 11 using propane as a fuel and a stainless can member 12 in which the honeycomb structural body 1 is secured via a heat-resistive ceramic mat.

The estimation test of the spalling strength was performed as follows. At first, the honeycomb structural body 1 secured in the stainless can member 12 is heated by using the burner 11. In this case, the heating operation was performed in such a manner that a gas temperature at a position 10 mm upstream of the honeycomb structural body 1 becomes a predetermined temperature (T°C) after 5 minutes from a start of the heating operation. After that, the honeycomb structural body 1 was cooled for 5 minutes after an end of the heating operation by flowing an air having a room temperature

through the honeycomb structural body 1. The above mentioned heating and cooling cycle was repeated 5 times. One heat curve of this cycle is shown in Fig. 4.

After that, the same estimation test was repeated under such a condition that the temperature T is increased by 25°C with respect to the honeycomb structural body 1 having no cracks. Then, a safety temperature was determined as the temperature T just before a defect such as cracks are generated in the honeycomb structural body 1. Moreover, a gas flow rate during the estimation test was 2.0 Nm<sup>3</sup>/minute when heating and 1.7 Nm<sup>3</sup>/minute when cooling.

Hereinafter, the results of the estimation test will be explained.

#### (1) As to the ratio of L/d:

At first, the spalling strength estimation test mentioned above was performed with respect to the cordierite honeycomb structural bodies 1, each having a porosity of 28% and a volume of 1 liter, in which a ratio of L/d is varied, so as to estimate the ratio of L/d. In this case, the spalling strength estimation test was performed to four series of the honeycomb structural bodies 1, first series having a partition wall thickness of 0.05 mm and a cell density of 100 pieces/cm<sup>2</sup>, second series having the partition wall thickness of 0.1 mm and the cell density of 100 pieces/cm<sup>2</sup>, third series having the partition wall thickness of 0.1 mm and the cell density of 150 pieces/cm<sup>2</sup>, and fourth series having the partition wall thickness of 0.05 mm and the cell density of 200 pieces/cm<sup>2</sup>. The results are shown in Fig. 5. Moreover, the substantially same results as those mentioned above were obtained for the honeycomb structural bodies 1 having a volume of 0.65 liter or 1.3 liter and for the honeycomb structural bodies 1 made of the other material such as alumina, SiC, or SiN having a porosity of 20% or 35%.

From the results shown in Fig. 5, it is understood that the spalling strength of the honeycomb structural body 1 is varied in response to a variation of the ratio of L/d. Moreover, it is understood that the safety temperature larger than 700°C, in which no drawbacks are detected during actual use, is shown in a range of 0.4-1.3. Further, as the fracture type, it is understood that the ring crack is largely generated when the ratio of L/d is larger than a point showing the largest safety temperature in Fig. 5 and the end crack is largely generated when the ratio of L/d is smaller than the point mentioned above. Furthermore, it is understood that the spalling strength is gradually larger from the L/d range of 0.6-1.1 to the L/d range of 0.7-1.0 as compared with that of the L/d range of 0.4-1.3, and is largest in the L/d range of 0.8-0.9. Therefore, it is understood that these L/d ranges are preferable.

#### (2) As to the partition wall thickness:

Then, the spalling strength estimation test men-

tioned above was performed with respect to the cordierite honeycomb structural bodies 1, each having a porosity of 28%, a volume of 1 liter, a cell density of 100 pieces/cm<sup>2</sup>, and a ratio of L/d of 1.4, in which the partition wall thickness is varied, so as to estimate the partition wall thickness. The results are shown in Fig. 6. From the results shown in Fig. 6, it is understood that the spalling strength is decreased in response to a decrease of the partition wall thickness. Moreover, it is understood that the spalling strength is decreased remarkably when the partition wall thickness is smaller than 0.1 mm. Therefore, it is understood that the present invention having an object of spalling strength improvement can be preferably applied if the honeycomb structural body has the partition wall thickness of smaller than 0.1 mm.

(3) As to the cell density:

Then, the spalling strength estimation test mentioned above was performed with respect to the cordierite honeycomb structural bodies 1 having a porosity of 28%, a volume of 1 liter, a partition wall thickness of 0.1 mm, and a ratio of L/d of 1.4, in which the cell density is varied, so as to estimate the cell density. The results are shown in Fig. 7. From the results shown in Fig. 7, it is understood that the spalling strength is decreased in response to an increase of the cell density. Moreover, it is understood that the spalling strength is decreased remarkably when the cell density is larger than 100 pieces/cm<sup>2</sup>. Therefore, it is understood that the present invention having an object of spalling strength improvement can be preferably applied if the honeycomb structural body has the cell density of larger than 100 pieces/cm<sup>2</sup>.

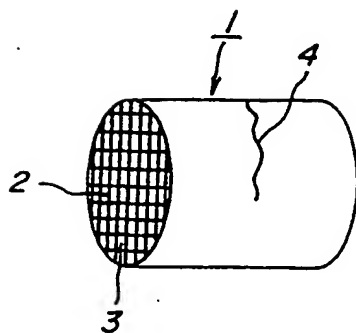
As clearly understood from the above explanation, according to the invention, since a ratio of L/d is set in a range of 0.4-1.3, preferably 0.6-1.1, more preferably 0.7-1.0, most preferably 0.8-0.9, where d is a diameter of an inscribed circle of the honeycomb structural body and L is a length thereof, the honeycomb structural body having an excellent spalling characteristic can be obtained.

Particularly, this effect is remarkable if the honeycomb structural body has the partition wall thickness of smaller than 0.1 mm and the number of passages of larger than 100 pieces per 1 cm<sup>2</sup>.

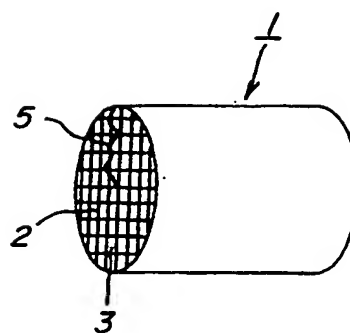
## Claims

1. The honeycomb structural body according to claim 1, wherein the ratio of L/d is in a range of 0.6-1.1, preferably 0.7-1.0, more preferably 0.8-0.9.
  2. The honeycomb structural body according to claim 1, wherein a thickness of the partition wall is smaller than 0.1 mm, and the number of passages on a plane perpendicular to the axial direction of the passage is larger than 100 pieces per 1 cm<sup>2</sup>.
  3. The honeycomb structural body according to claim 1, wherein the honeycomb structural body is formed by ceramic material or materials selected from a group of cordierite, alumina, SiC and SiN.
  4. The honeycomb structural body according to claim 1, wherein the honeycomb structural body is used as a catalyst carrier for purifying an exhaust gas from an internal combustion engine.
1. A honeycomb structural body comprising a plurality of passages aligned in its axial direction which are defined by partition walls, wherein a ratio of L/d is in a range of 0.4-1.3, where d is a diameter of an inscribed circle of the periphery of the honeycomb structural body on a plane perpendicular to its axial direction, and L is a length along the axial direction of the honeycomb structural body.

**FIG. 1a**



**FIG. 1b**



**FIG. 2**

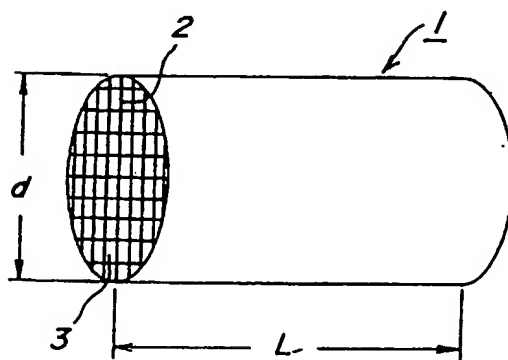
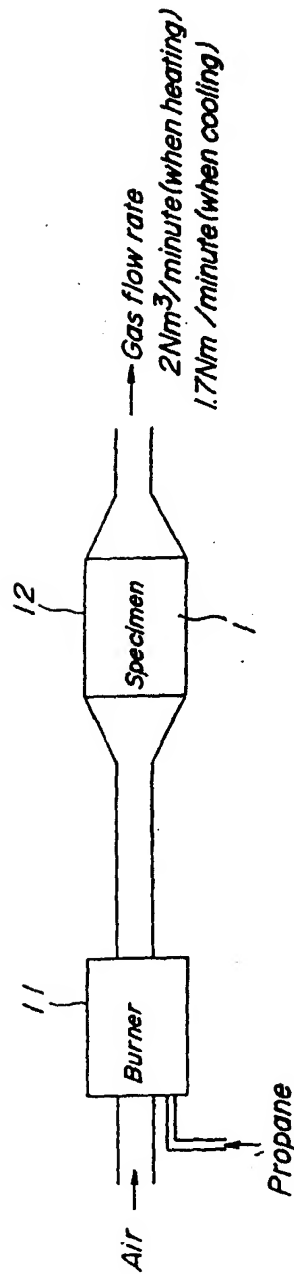


FIG. 3



**FIG. 4**

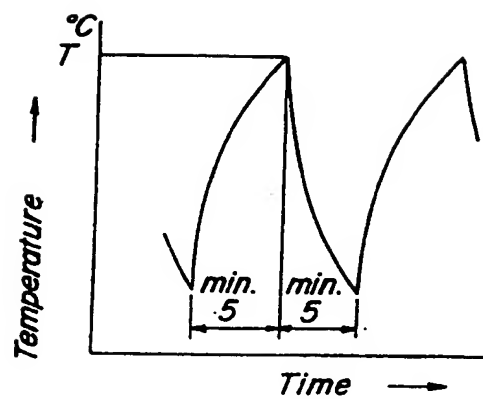
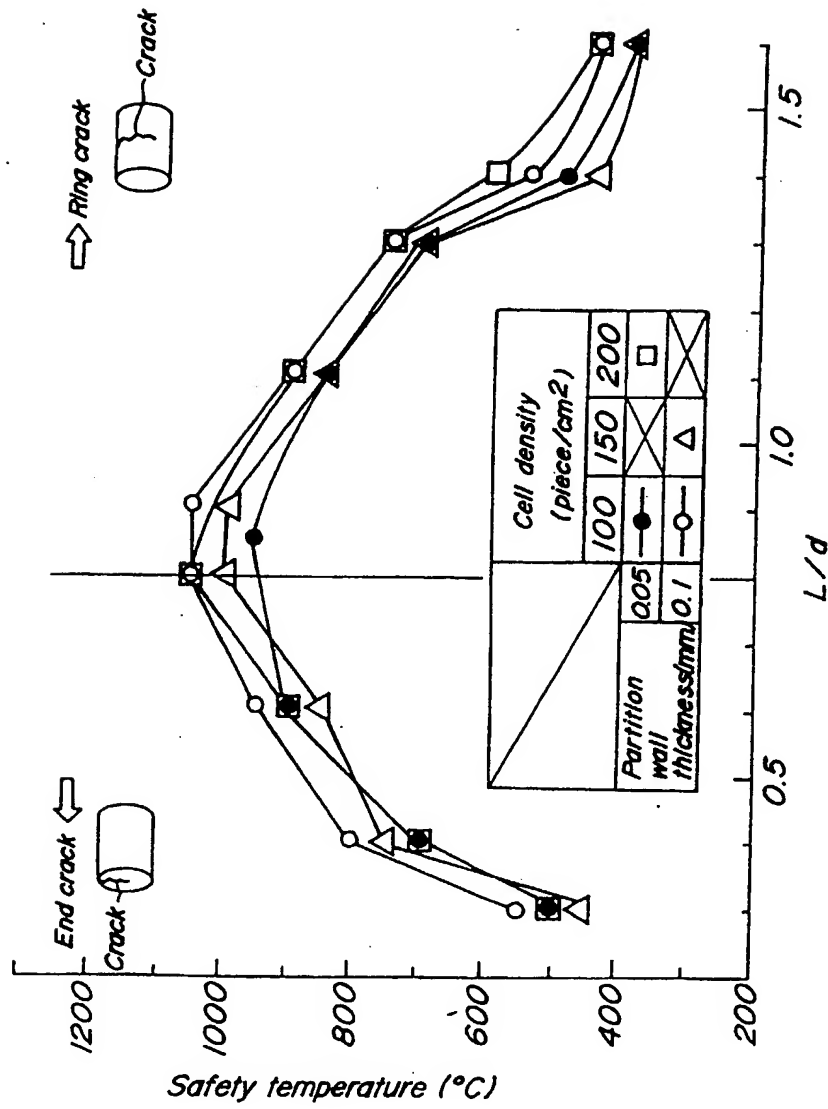


FIG. 5





**FIG. 6**

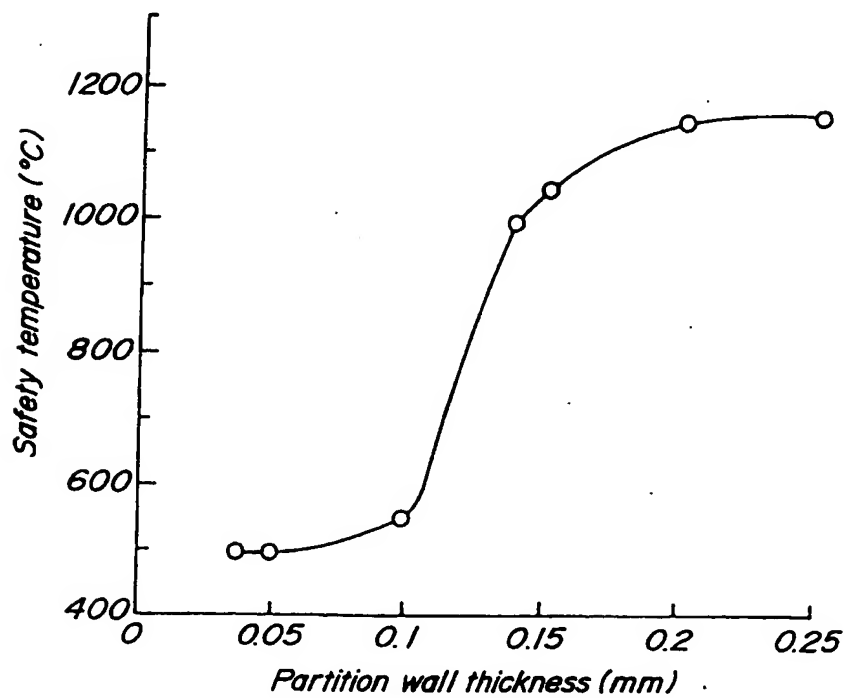
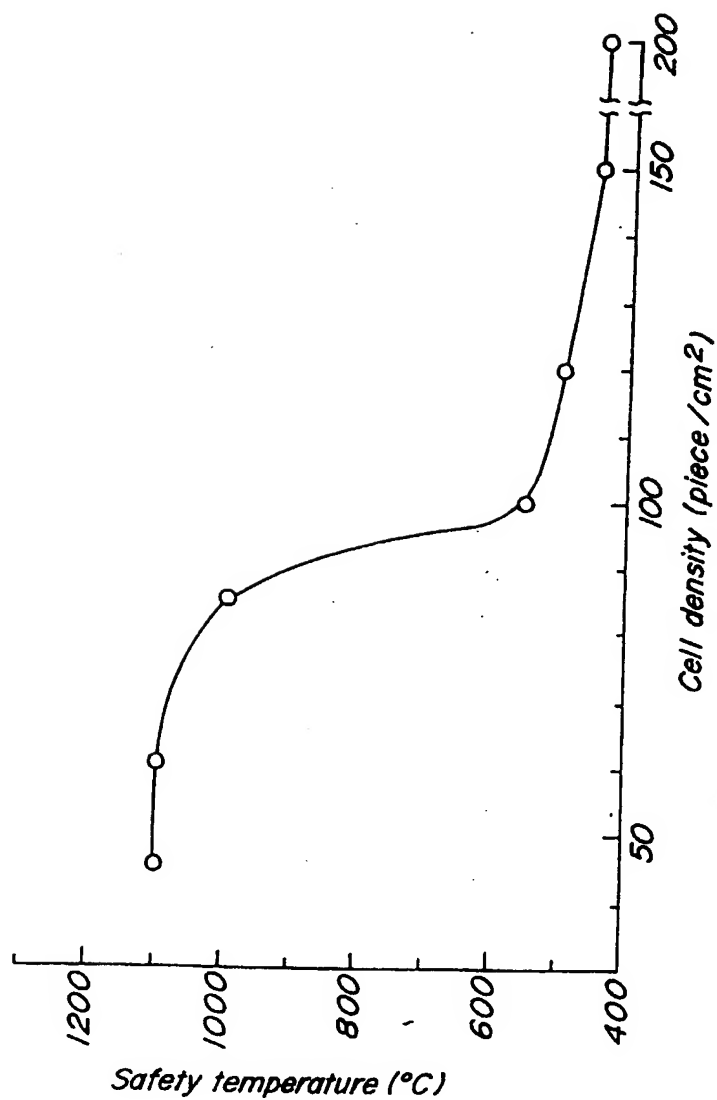


FIG. 7





Europäisches Patentamt  
European Patent Office  
Office européen des brevets



(11) **EP 0 807 466 A3**

(12) **EUROPEAN PATENT APPLICATION**

(88) Date of publication A3:  
29.12.1997 Bulletin 1997/52

(51) Int Cl.<sup>6</sup>: **B01J 35/04**

(43) Date of publication A2:  
19.11.1997 Bulletin 1997/47

(21) Application number: **97303329.3**

(22) Date of filing: **16.05.1997**

(84) Designated Contracting States:  
**DE FR GB IT**

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(54) **Honeycomb structural body**

(57) A honeycomb structural body (1) comprises a plurality of passages (3) aligned in its axial direction which are defined by partition walls (2). The ratio of L/D is in the range of 0.4-1.3, where d is a diameter of an inscribed circle of the periphery of the honeycomb struc-

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**EP 0 807 466 A3**



European Patent  
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## EUROPEAN SEARCH REPORT

Application Number  
EP 97 30 3329

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (InCL6)
X	EP 0 638 710 A (NGK INSULATORS LTD) 15 February 1995 * page 7, line 20; example 1 *	1-5	B01J35/04
X	US 4 556 543 A (MOCHIDA SHIGERU ET AL) 3 December 1985 * examples *	1,2,4,5	
X	EP 0 444 494 A (DEGUSSA) 4 September 1991 * example 2 *	1-3,5	
X	US 5 356 852 A (DELISO EVELYN M ET AL) 18 October 1994 * column 6, line 18; example 1 *	1-3	
X	EP 0 241 269 A (NGK INSULATORS LTD) 14 October 1987 * page 3, line 6-28 *	1,2,4,5	
X	US 5 286 460 A (ABE FUMIO ET AL) 15 February 1994 * column 4, line 37-65 *	1-5	
			TECHNICAL FIELDS SEARCHED (InCL6)
			B01J
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
MUNICH	24 October 1997	Schwallier, J-M	
CATEGORY OF CITED DOCUMENTS			
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Docket # E-41422  
Applic. # 10/014,265  
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EPO FORM 150 (2-92) (P4001)